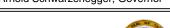
#### DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES Office of Structural Materials

Quality Assurance and Source Inspection

Bay Area Branch 690 Walnut Ave.St. 150 Vallejo, CA 94592-1133

(707) 649-5453 (707) 649-5493



Contract #: 04-0120F4

Cty: SF/ALA Rte: 80 PM: 13.2/13.9

File #: 69.28

## WELDING INSPECTION REPORT

Resident Engineer: Siegenthaler, Peter **Report No:** WIR-018015 Address: 333 Burma Road **Date Inspected:** 31-Oct-2010

City: Oakland, CA 94607

**OSM Arrival Time:** 700 **Project Name:** SAS Superstructure **OSM Departure Time:** 1900 **Prime Contractor:** American Bridge/Fluor Enterprises, a JV

Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

**CWI Name: CWI Present:** Yes No An Qing Xing **Inspected CWI report:** Yes N/A **Rod Oven in Use:** Yes No No N/A N/A **Electrode to specification:** Yes No Weld Procedures Followed: Yes No N/A N/A **Qualified Welders:** Yes No **Verified Joint Fit-up:** Yes No N/A N/A N/A **Approved Drawings:** Yes No **Approved WPS:** Yes No Yes No N/A **Delayed / Cancelled:** 

34-0006 **Bridge No: Component: OBG COMPONENT** 

#### **Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Subhasis Bera was present during the times noted above for observations relative to the work being performed.

In process Inspection

Outside Yard

This QA Inspector observed the following work in progress:

SMAW in the 3G position for the OBG segment 11BE to 11CE, weld No.SP715-001-034. The welder is identified as #044515. ZPMC QC is identified as Mr. An Qing Xing. The welding variables recorded by QC appear to comply with WPS-B-P-2213-B-U2-FCM-1.

SMAW in the 3G position for the OBG segment 11BE to 11CE, weld No.SP354-001-055. The welder is identified as #050289. ZPMC QC is identified as Mr. An Qing Xing. The welding variables recorded by QC appear to comply with WPS-B-P-2213-B-U2-FCM-1.

SMAW in the 3G position for the OBG segment 11BE to 11CE, weld No.OBE11-010. The welder is identified as #500363. ZPMC QC is identified as Mr. An Qing Xing. The welding variables recorded by QC appear to comply with WPS-B-P-2213-B-U2-FCM-1.

FCAW in the 2F position for the OBG segment 11BE to 11CE, weld No.BP187-001-045. The welder is identified as #040367. ZPMC QC is identified as Mr. An Qing Xing. The welding variables recorded by QC appear to

### WELDING INSPECTION REPORT

(Continued Page 2 of 3)

comply with WPS-B-T-2132.

Ultrasonic Testing (UT) for Service Platform at Bay#9

This QA Inspector performed Ultrasonic testing (UT) 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The members are identified as OBG service platform weld joints.

The welds designation reviewed are as follows:

SP4-B-001-001,002,003 SP7-B-001-001,002,003 SP8-B-001-001,002,003

Magnetic Particle Testing (MPT) for Service Platform at Bay#9

This Quality Assurance (QA) Inspector performed Visual inspection and verification of Magnetic Particle Testing (MT) 15% for OBG traveler rail weld. This QA inspector generated a (MT) report for this date .This area was previously tested and accepted by ZPMC QC MT technicians.

The Weld Designations are as follows

SPEP2-004-001

SPEP2-005-001

SPEP2-006-001

SPEP2-007-001

SPEP2-008-001

Visual Inspection after Blast at OBG service platform component

This Quality Assurance (QA) Inspector performed random visual inspection of OBG service platform component external surfaces after grit blasting at front of blast shop no.2. Areas that were marked by QA requiring additional grinding and repaired by ZPMC personnel.

The components are identified as SP5-6,SP5-7,SP5-8,SP6-6,SP6-7,SP6-8 and miscellaneous item .

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

# WELDING INSPECTION REPORT

(Continued Page 3 of 3)









# **Summary of Conversations:**

No relevant conversations

#### **Comments**

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Bera, Subhasis	Quality Assurance Inspector
Reviewed By:	McClendon, Timothy	QA Reviewer